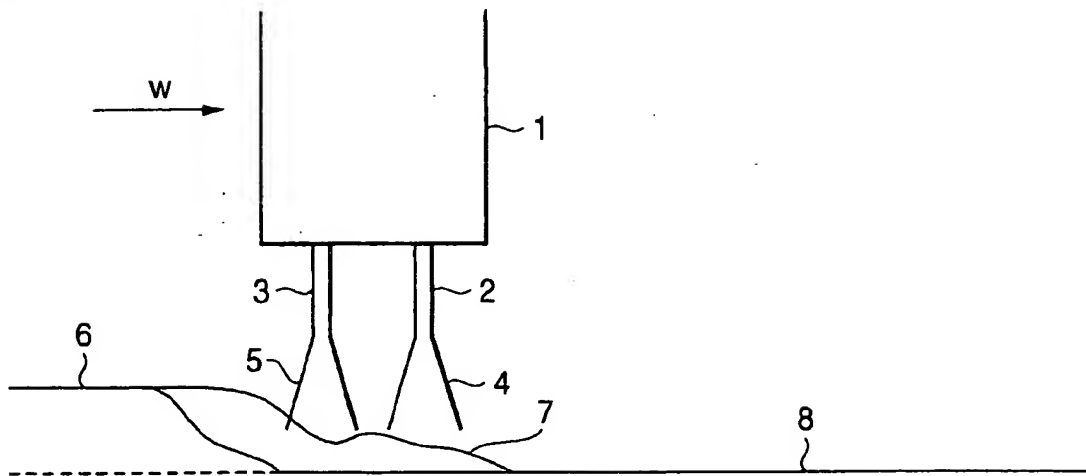
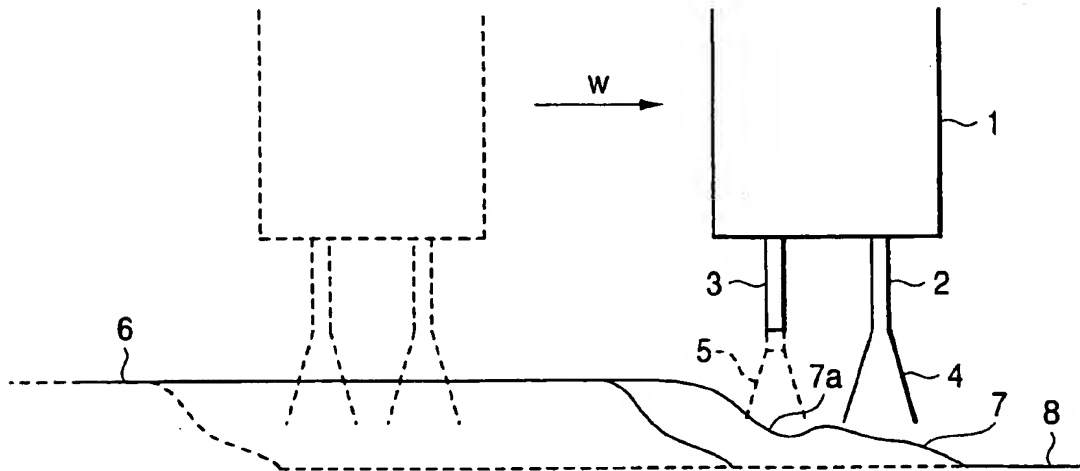


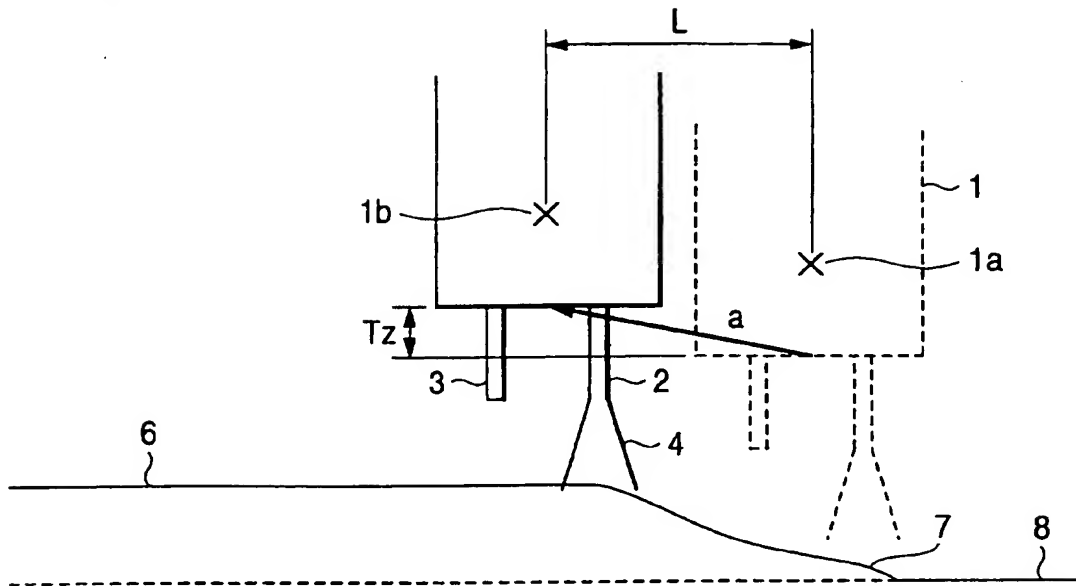
~~[図1]~~ Fig. 1



~~[図2]~~ Fig. 2



~~Fig. 3~~ Fig. 3



~~Fig. 4~~ Fig. 4

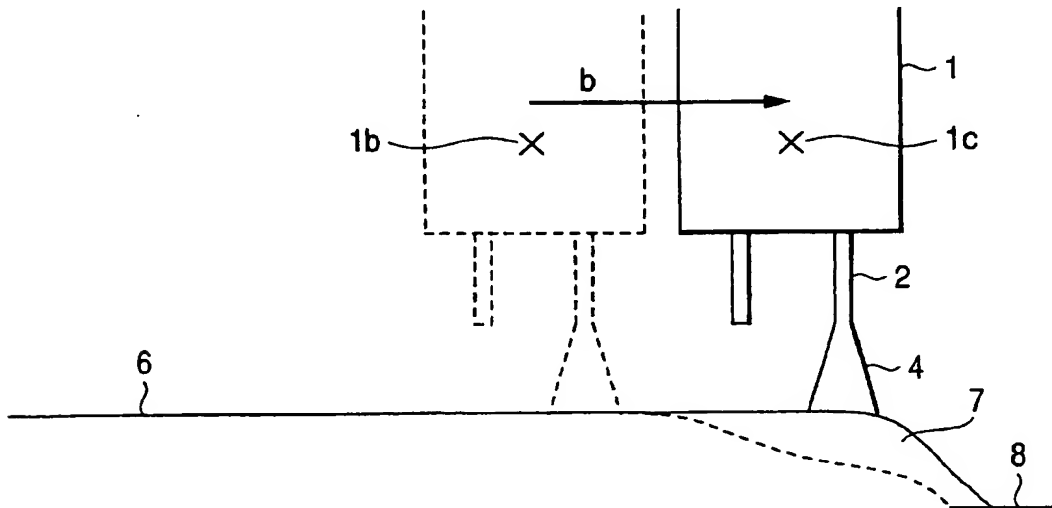


Fig. 5
 [図5]

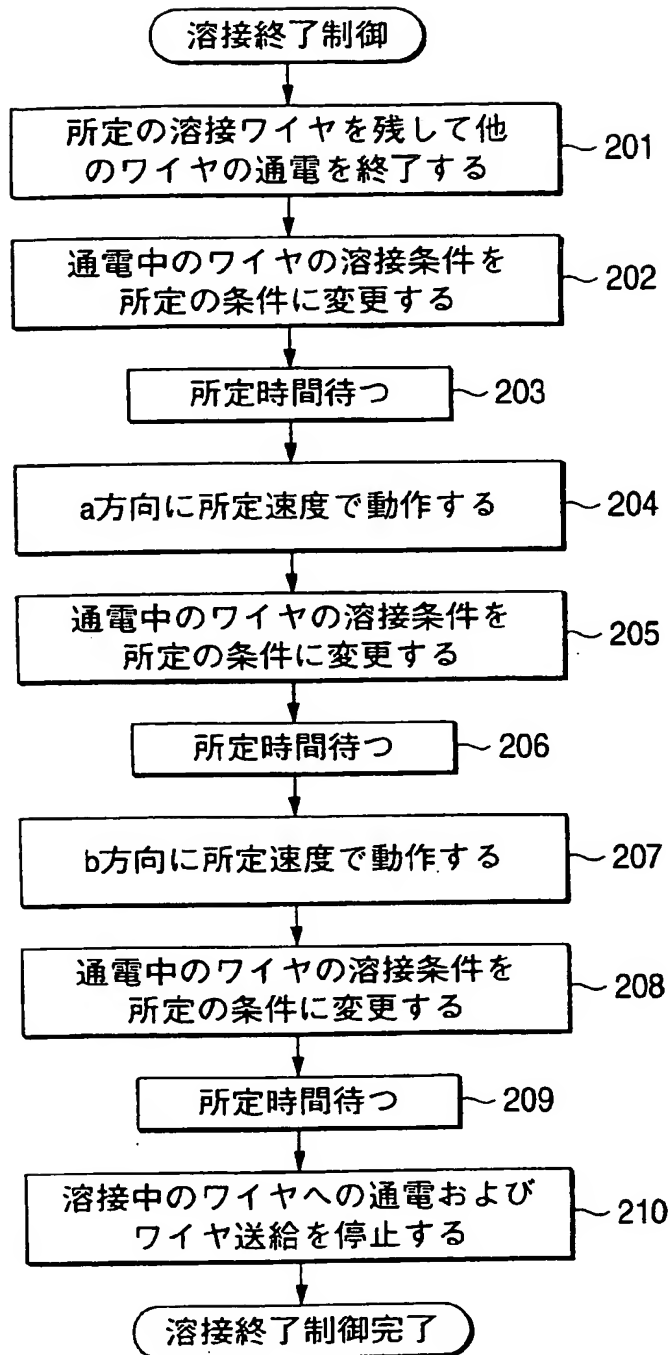


Fig. 5

WELDING TERMINATION CONTROL

201: TERMINATE ENERGIZATION OF ALL WELDING WIRES EXCEPT FOR A SPECIFIED WELDING WIRE.

202: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

203: WAIT FOR A GIVEN TIME.

204: MOVE A TORCH AT A GIVEN TIME IN THE a DIRECTION.

205: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

206: WAIT FOR A GIVEN TIME.

207: MOVE A TORCH AT A GIVEN TIME IN THE b DIRECTION.

208: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

209: WAIT FOR A GIVEN TIME.

210: STOP ENERGIZATION AND FEEDING OF THE WELDING WIRES BEING WELDED.

END OF WELDING TERMINATION CONTROL

Fig. 6

WELDING TERMINATION CONTROL

301: TERMINATE ENERGIZATION OF ALL WELDING WIRES EXCEPT FOR A SPECIFIED WELDING WIRE.

302: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

303: WAIT FOR A GIVEN TIME.

304: MOVE A TORCH AT A GIVEN TIME IN THE a DIRECTION.

305: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

306: WAIT FOR A GIVEN TIME.

307: MOVE A TORCH AT A GIVEN TIME IN THE b DIRECTION.

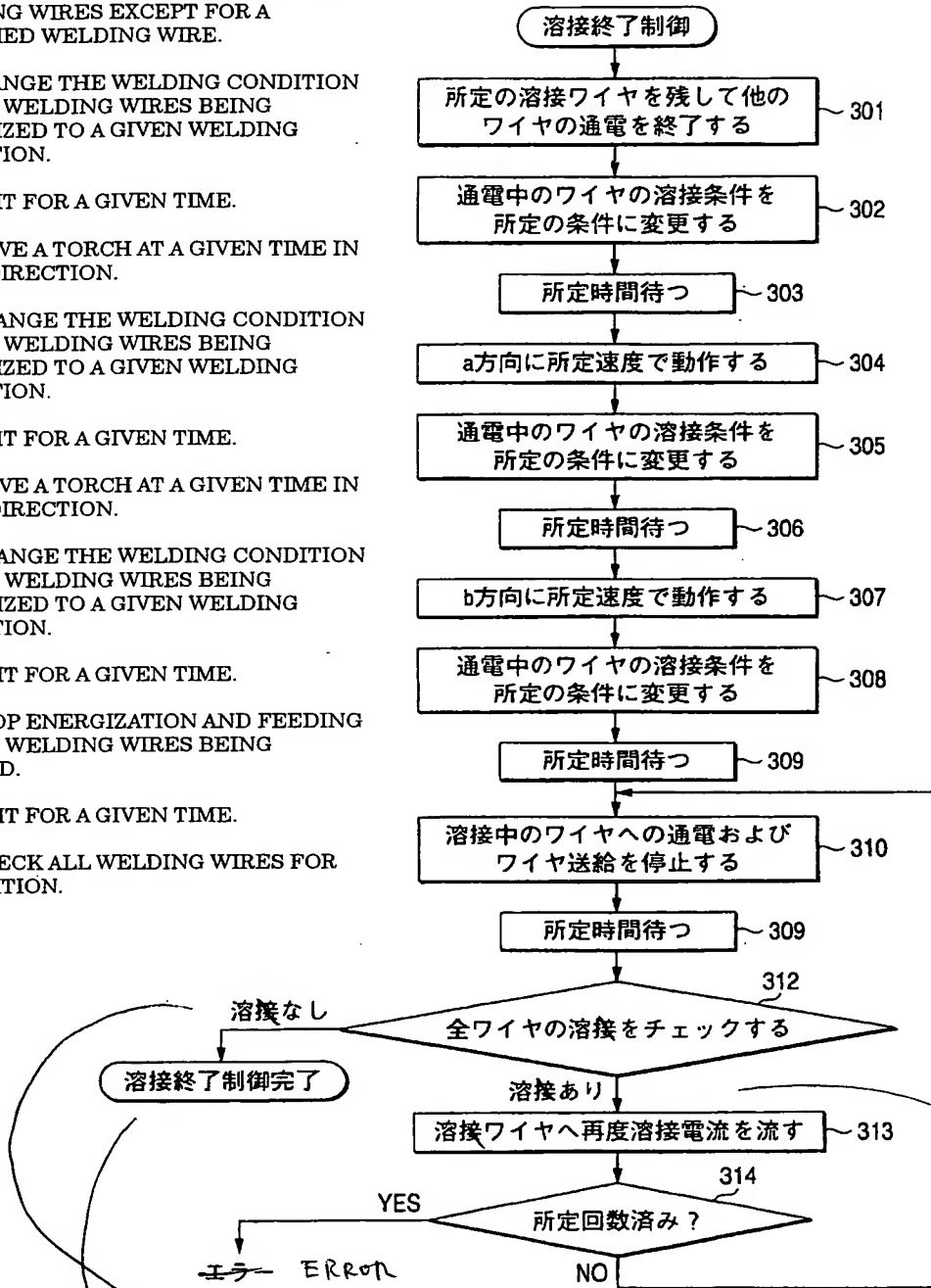
308: CHANGE THE WELDING CONDITION OF THE WELDING WIRES BEING ENERGIZED TO A GIVEN WELDING CONDITION.

309: WAIT FOR A GIVEN TIME.

310: STOP ENERGIZATION AND FEEDING OF THE WELDING WIRES BEING WELDED.

309: WAIT FOR A GIVEN TIME.

312: CHECK ALL WELDING WIRES FOR DEPOSITION.



NO DEPOSITED WIRE IS FOUND.
FINISH THE WELDING TERMINATION CONTROL.
DEPOSITED WIRE IS FOUND.

313: APPLY A WELDING CURRENT TO THE DEPOSITED WIRE AGAIN.

314: IF A SERIES OF PROCESSINGS HAVE BEEN EXECUTED A GIVEN NUMBER OF TIMES?

~~ERROR~~